

Date: Monday, 3/26/2007 3:01:55 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L UTILITY BASKET
Job Number	: 31454		
Estimate Number	: 11272		
P.O. Number	: <i>N/A</i>	Part Number	: D206540011
This Issue	: 3/26/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D206-540 REV I
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: I
Previous Run	: 31253	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/6/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.03.27		
Comment	: Est Rev: I Revised per Rev I 05-12-06 JLM Est Rev: H 07-03-20 As per DSI9361 JLM		

## Additional Product

Job-Number: 

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



*KS 07-03-28*

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-540-011 CHC004

*CH6005*

*07.03.29*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

3.0	31454A	206L BASKET BASE - UNDER REVIEW
-----	--------	---------------------------------



Comment: Sub-Component 206L BASKET BASE

D2252-041 B *31454A*

*ml 07/04/20*

4.0	31454B	206L BASKET LID - UNDER REVIEW
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Comment: Sub-Component 206L BASKET LID

D2252-043 B *31454B*

*ml 07/04/20*

5.0	D2332041	Lid Prop Assembly 6.69"
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y *30547*

*7/4/20 59*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:01:55 PM  
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## Process Sheet

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Drawing Name: 206L UTILITY BASKET

Job Number: 31454

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER 1326664

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment 30383

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring 529363

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing 1329536

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 D2931 Bumper 1321139

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet 1101519

7/4/20 59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 31454

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt M100327

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-24A

Bolt M101938

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt M101884

15.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt M100771

16.0

AN517A

Bolt



Comment: Qty.: ~~2~~ 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN5-17A

Bolt M102140

17.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD416

Washer M102929

7/4/20 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

Date: Monday, 3/26/2007 3:01:55 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 31454

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M102519

19.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M103344

20.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD8 Washer M103492

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M102658

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) 4103914

23.0

D2258170

Placard - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2258-170 PLACARD

1316266 7/4/20 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 3/26/2007 3:01:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 31454

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M102538

25.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Dart Logo label large

Batch: B22553

26.0

D33963

Inventory



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Batch: B26772

7/4/20 59

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-540

m 07/04/20 X

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20704-20 @

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

30.0

D2249041

Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 d2249-041 bracket

B31031 ✓

CP 07/04/20 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 31454

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

D2259

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2259

Placard

B10671 ✓

✓

32.0

D2525

Spacer Kit



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2525

Spacer kit

B27554 ✓

✓

33.0

D2526

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2526

Bushing

B23139 ✓

✓

34.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2537

BUSHING

B29536 ✓

✓

35.0

D2748

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2748

Clevis

B23416 ✓

✓

36.0

D27495

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-5

Strut

B24137 ✓

✓

37.0

D27497

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-7

Strut

B17529 ✓

✓

✓  
J. S. / 3/26/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 31454

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

111695 ✓

✓

39.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A Bolt

1100857 ✓

✓

40.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12A Bolt

1102029 ✓

✓

41.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A Bolt

1102140 ✓

✓

42.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer

1102929 ✓

✓

43.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516 Washer

1102519 ✓

✓

✓ 04/04/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RD Date: 07/04/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:01:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 31454

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

M103914

✓

45.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5

Nut

M102536 ✓

✓

Boyle/20 ①

46.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



u 07-04-20

Comment: INSPECT 100% KITS FOR COMPLETENESS

Boyle/20 ①

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-011

Location:

PPP Rev:

H

Boyle/20 ①

48.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

Boyle/20

Job Completion



u 07-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

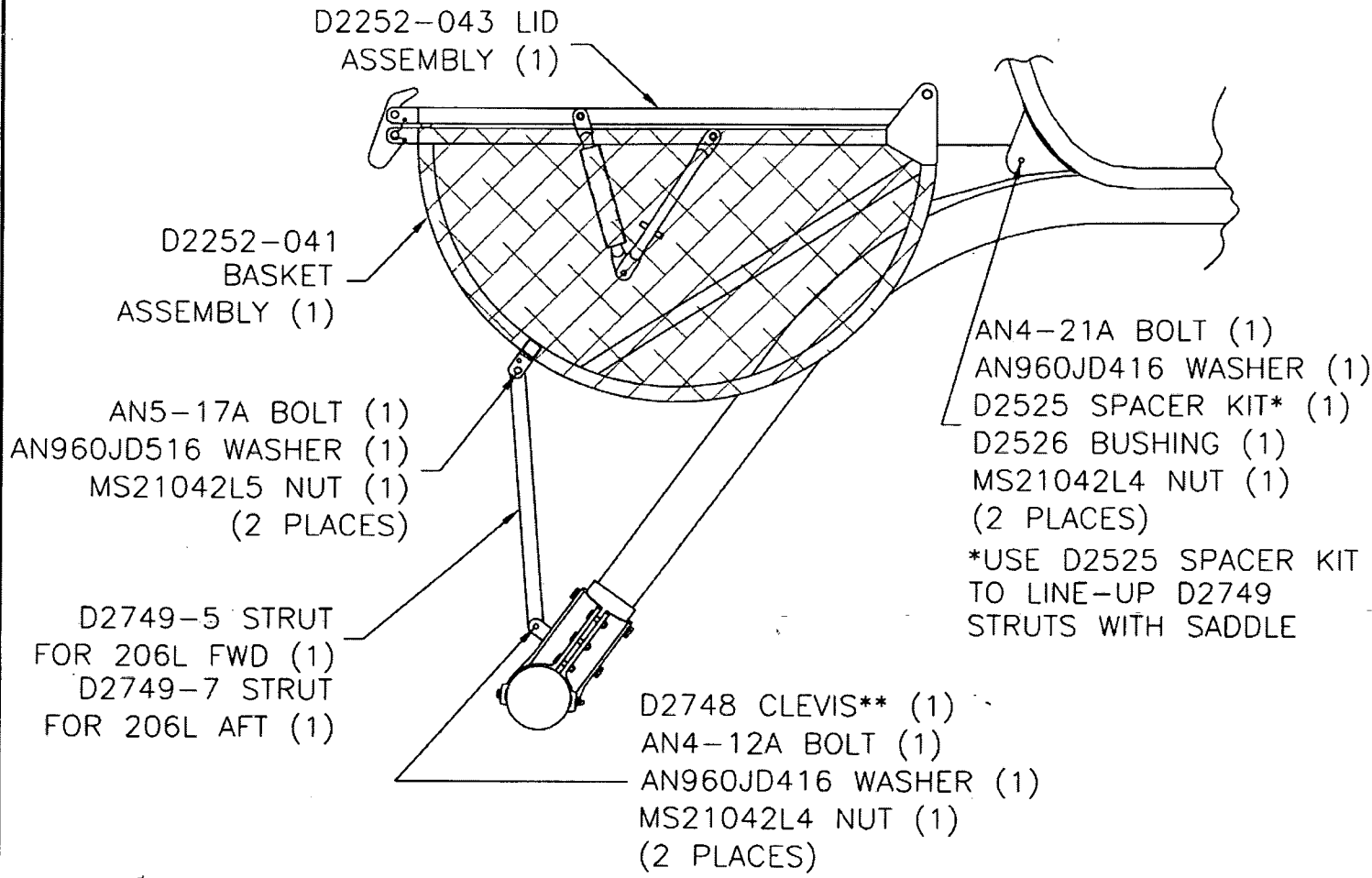
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN		DRAWN BY		DART AEROSPACE LTD	
KE		MB		HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. 1
05.11.10		D206-540		SHEET 7 OF 8	
DATE		TITLE		SCALE	
		UTILITY BASKET INSTALLATION		N1S	



\*\*NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748 CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

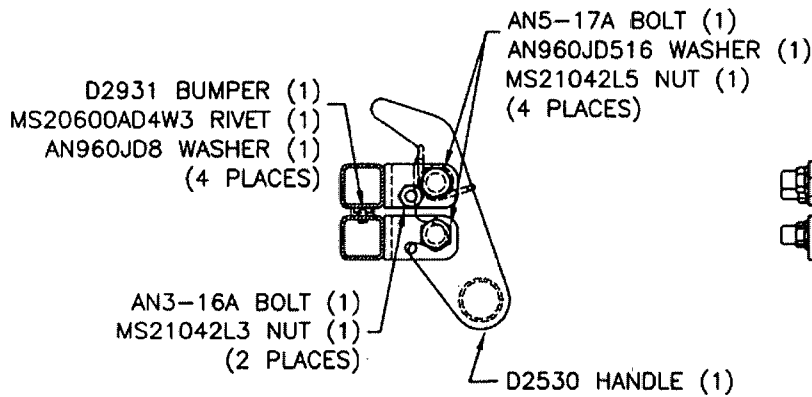
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
NO. 31454  
WORK ORDER

SECTION D-D AND E-E  
D206-540-011 (206 L/L1/L3/L4) ONLY

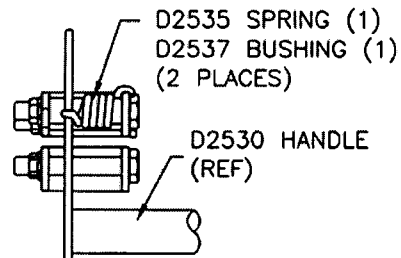
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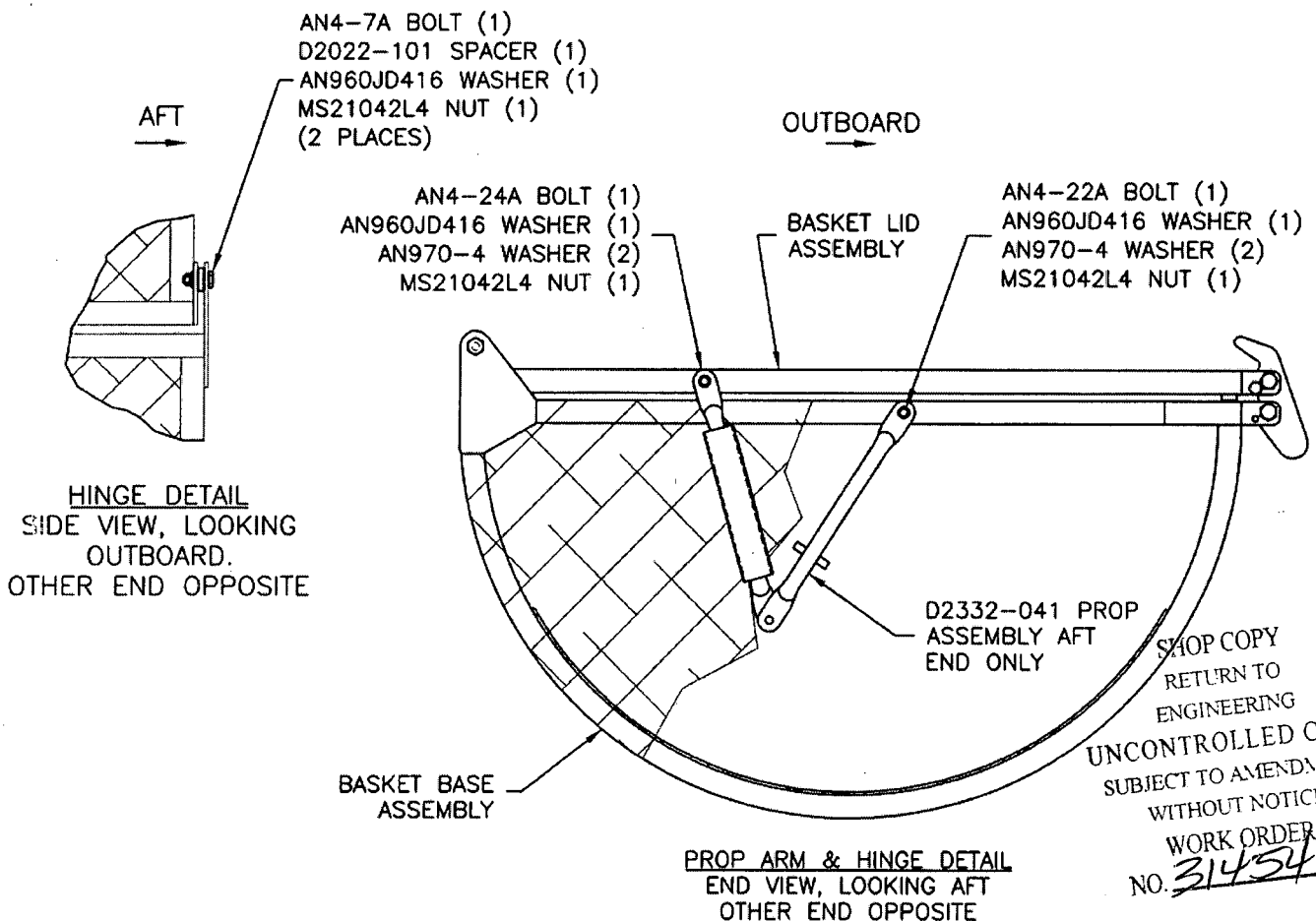
DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-540	REV. 1 SHEET 8 OF 8
DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



LATCH DETAIL



SPRING DETAIL



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31454

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DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9361	REV. A SHEET 1 OF 1
DATE 07.03.15		TITLE UTILITY BASKET SPACER	SCALE NTS
A	07.03.15	NEW ISSUE	

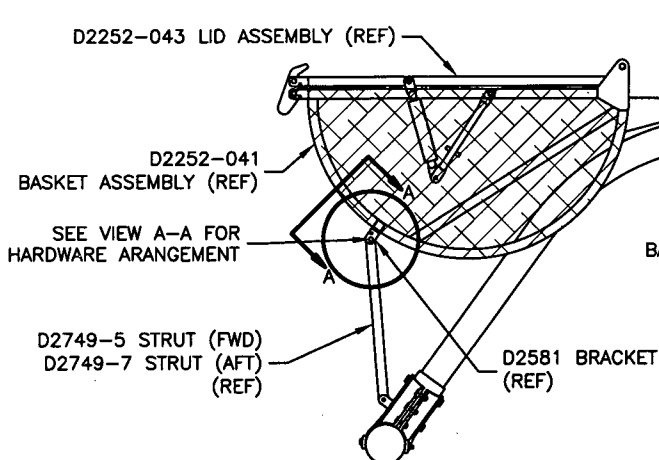
## DART SERVICE INSTRUCTION

TO AMEND DART INSTALLATION DRAWING D206-540 REV. I  
REF. CANADIAN STC: SH94-5  
REF. FAA STC: SR00386NY

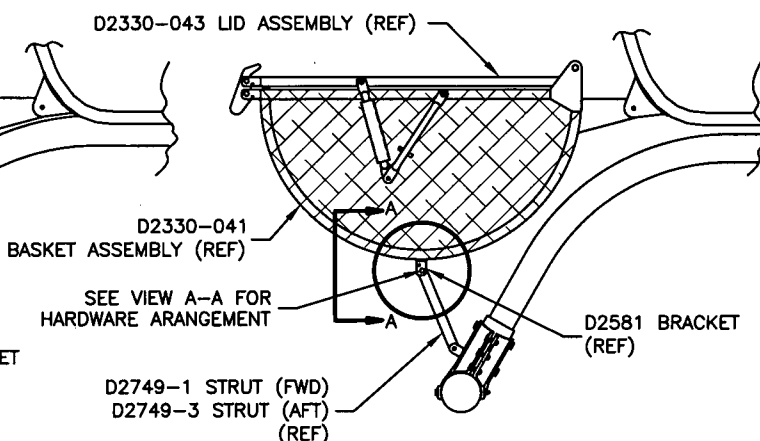
The following parts will be **added** to the Parts List on page 1 of Installation Drawing D206-540.

Qty - 011	Qty - 013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
4	4	D3396-3	SPACER

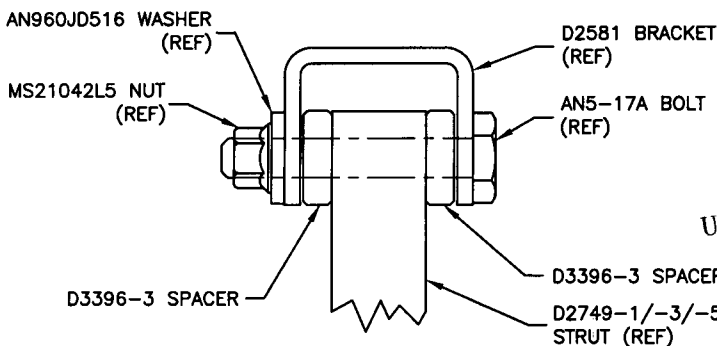
Install qty(2) D3396-3 Spacers per strut at the location shown in **Figure 1** (for D206-540-011 kit) and **Figure 2** (for D206-540-013 kit). Install hardware per View A-A



**FIGURE 1 - D206-540-011  
INSTALLATION**



**FIGURE 2 - D206-540-013  
INSTALLATION**



**VIEW A-A - HARDWARE  
ARRANGEMENT (TYP)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31454

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 07.03.15  
CERT. NO.: SH94-5  
ISSUE NO.: 4

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Date: Monday, 3/26/2007 3:02:36 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L BASKET LID - UNDER REVIEW
Job Number	: 31454B		
Estimate Number	: 11274		
P.O. Number	: N/A	Part Number	: D2252043
This Issue	: 3/26/2007 S.O. No. : N/A	Drawing Number	: D2252 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 31253B	Material	: N/A
Written By	: <u>HA</u>	Due Date	: 4/6/2007
Checked & Approved By	: <u>HA 07.03.27</u>	Qty:	1 Um: Each
Comment	: Est Rev: REVISED AS PER REV E 05-12-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304TS0750W065	304 SQ Tube 75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s)  
3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M103987

Cpl 07.02.19

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2252-1-3-9 as per Dwg D2252

2-Drill hole in D2252-1 as per Dwg D2252

3-Deburr & Remove all Markings from Material

Cpl 07.04.19

3.0	D2329	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2329	Label Plate	<u>B29936</u>

Cpl 07.04.19

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2327-1	Bushing	<u>B28334</u>

Cpl 07.04.19

(PTO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/17	4.0	Put A2327-1 on wrong side of Basket	AS1042	Cut and remove A2327-1 and plug hole with weld Reweld A2327-1 as per drawing	07/04/17	07/04/17	AS1042	07/04/17

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:02:36 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID - UNDER REVIEW

Job Number: 31454B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

HINGE

B29535

Cpl 07-04-19

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Chancel

B30552

Cpl 07-04-19

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total: 18.9000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M103949

Cpl 07-04-19

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Debur as required

A/R SS ROD

Batch: M101972

Cpl 07-04-19

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/19

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/19

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-04-19 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/04/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:02:36 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID - UNDER REVIEW

Job Number: 31454B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*ml 07/04/20*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*ml 07/04/20*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*①  
12/07/04/20*

Job Completion



*U 07.04.20*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

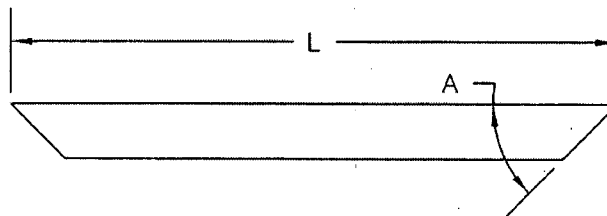
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DATE <b>05.11.10</b>		TITLE <b>BASKET ASSEMBLY (206L)</b>	SCALE <b>NTS</b>
<b>C</b>	<b>95.12.11</b>	<b>RE-DRAWN</b>	
<b>D</b>	<b>99.09.14</b>	<b>MODIFIED LATCH, D2581 WAS D2255-3</b>	
<b>E</b>	<b>05.11.10</b>	<b>D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 &amp; D2252-19</b>	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	• 25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	• 24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	• 30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

**NOTES:**

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

**CUT SIZE DETAIL**

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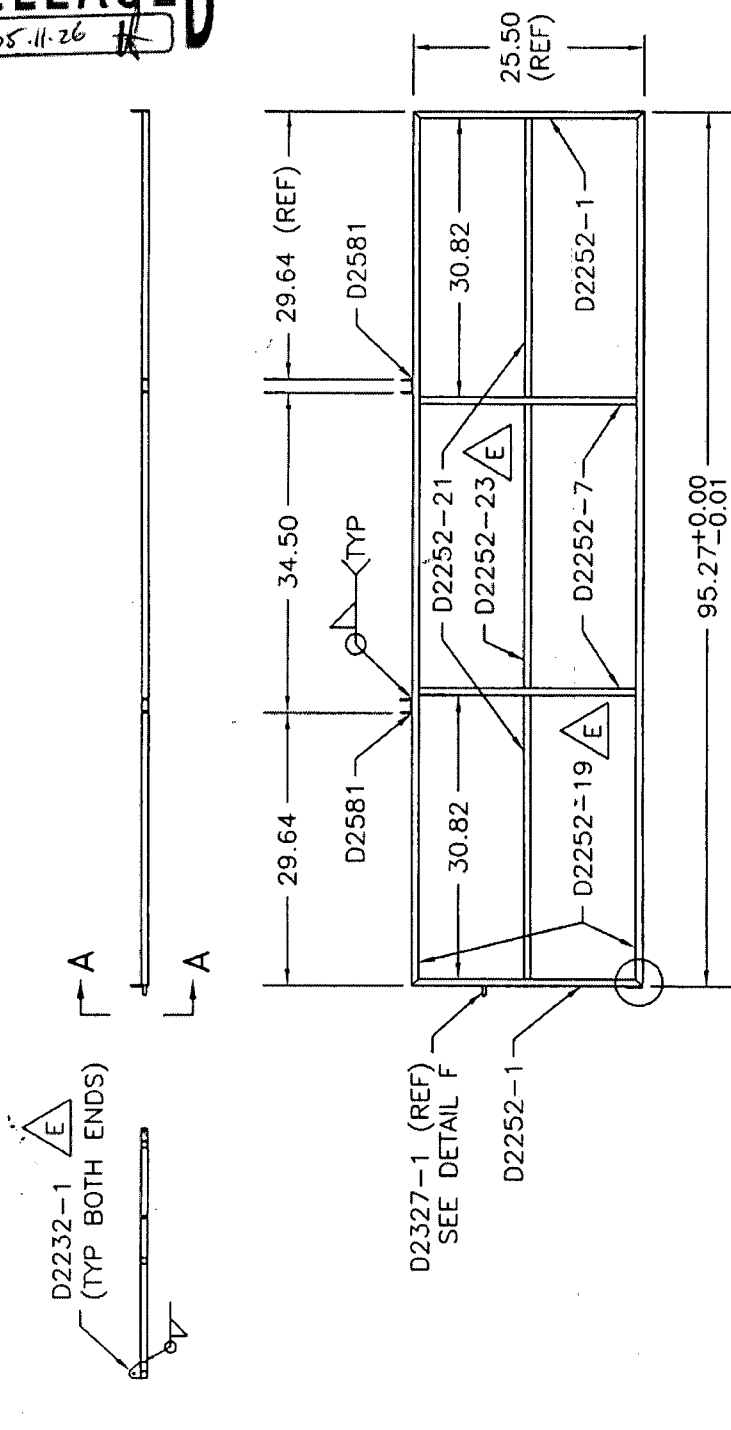
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)		SCALE NTS

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05.11.26



D2252-043 LID FRAME



WELD ALL JOINTS  
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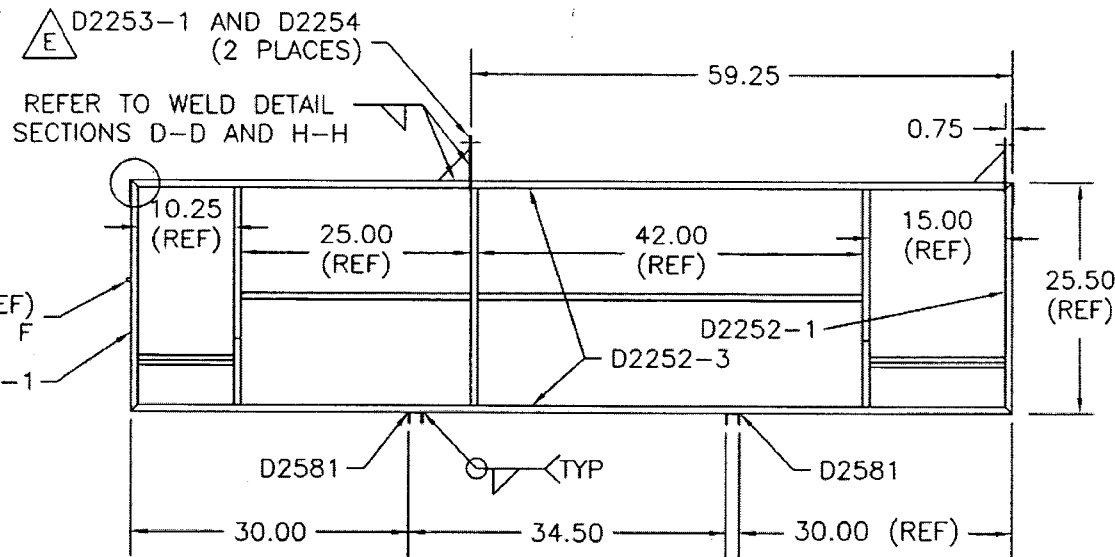
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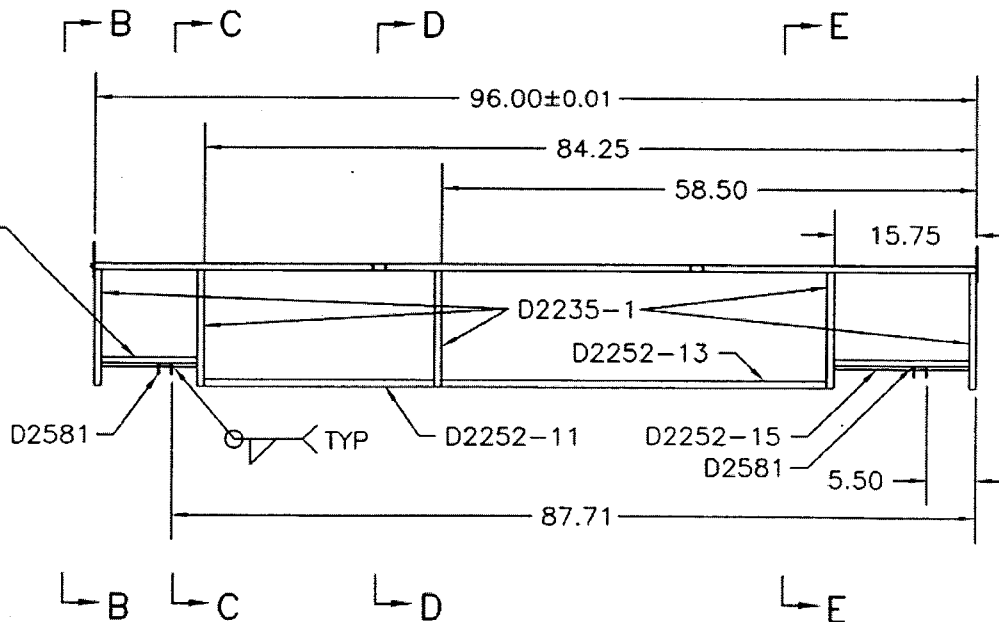
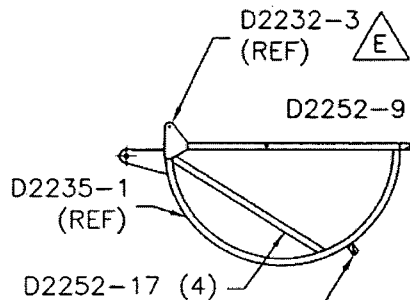
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DATE	05.11.10	DRAWING NO.	D2252	REV. E
		TITLE	BASKET ASSEMBLY (206L)	SHEET 3 OF 5
		SCALE	NTS	



WELD ALL JOINTS  
AS SHOWN



D2252-041 BASKET FRAME

**RELEASED**  
05.11.26

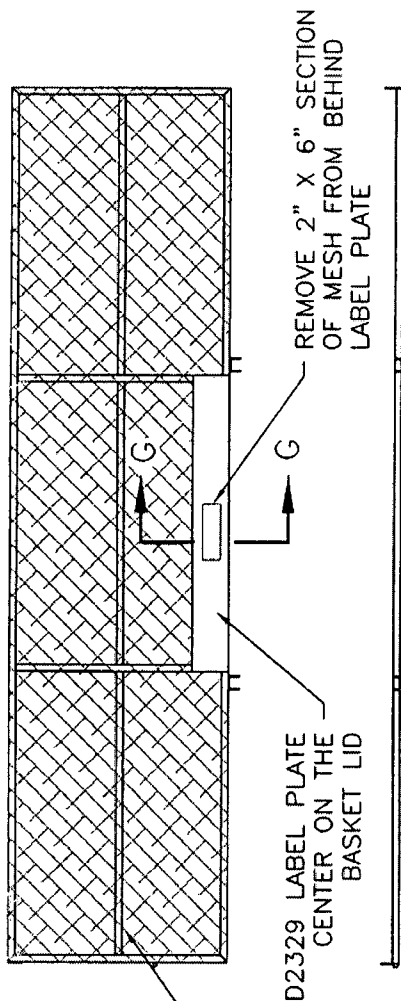
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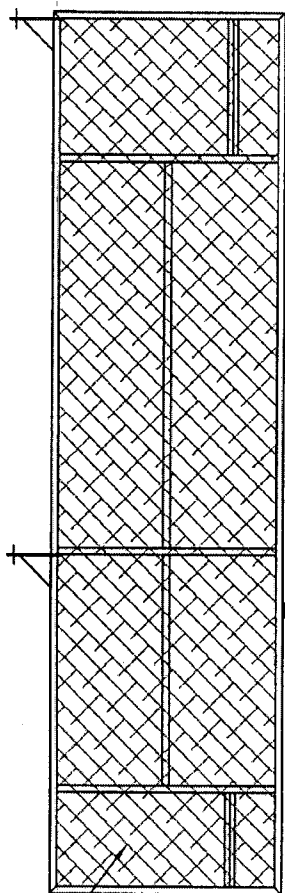
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)		SCALE NTS

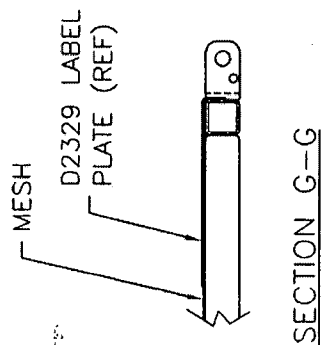


D2252-043 LID ASSEMBLY

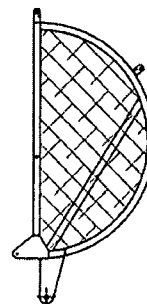


D2252-041 BASKET ASSEMBLY

RELEASED  
05.11.26 *[Signature]*



SKIN WITH 3/4-16 F EXPANDED SS, TACK WELD EACH STRAND END TO FRAME



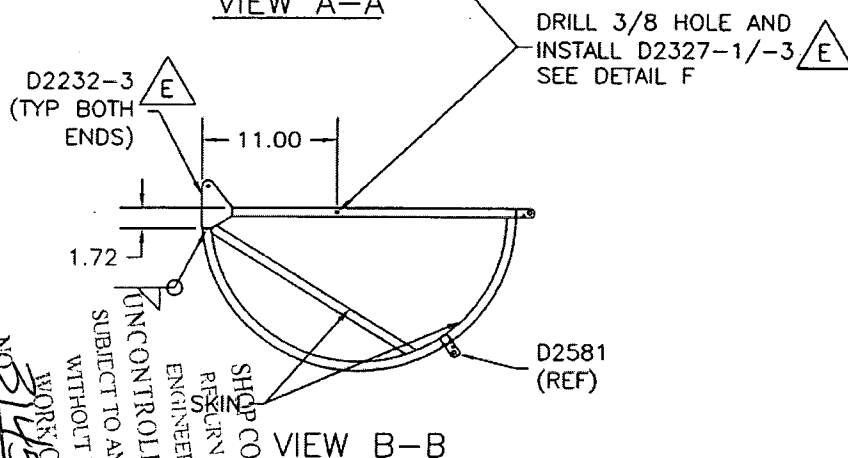
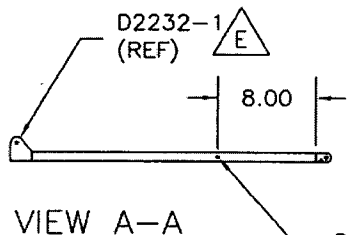
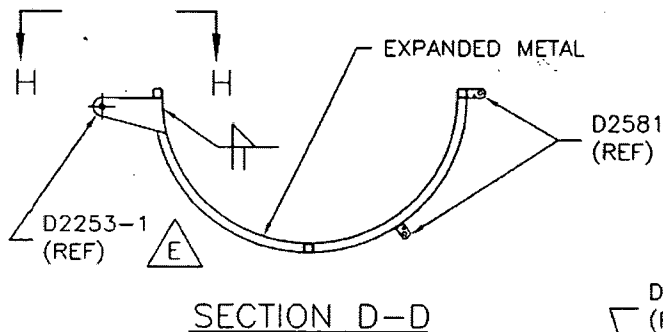
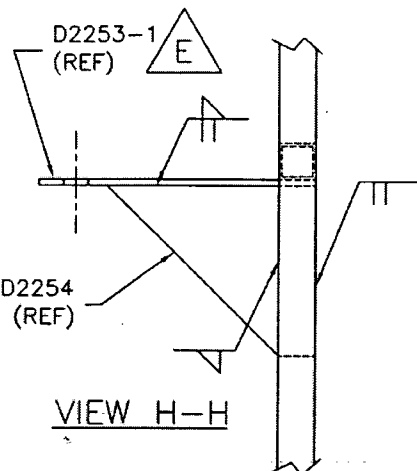
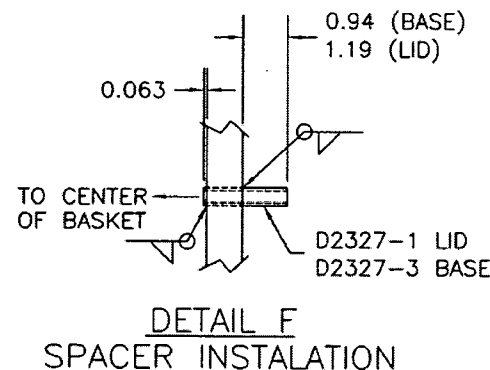
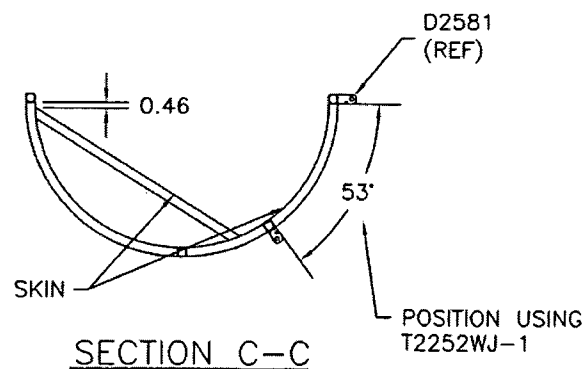
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2252
DATE	05.11.10	TITLE	BASKET ASSEMBLY (206L)	REV. E SHEET 5 OF 5
		SCALE	NTS	



**RELEASED**  
05.11.26

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Date: Monday, 3/26/2007 3:02:19 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L BASKET BASE - UNDER REVIEW
Job Number : 31454A	
Estimate Number : 11273	
P.O. Number : N/A	Part Number : D2252041
This Issue : 3/26/2007 S.O. No. : N/A	Drawing Number : D2252 UNDER REVIEW <i>02.03.27</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E
Previous Run : 31253A	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 4/6/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i> <i>07.03.27</i>	
Comment : Est Rev. Revised as per Rev E 05-12-06 JLM	

## Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 D31661 Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part# Description Batch  
 5 D3166-1 Hoop *B31491*

*P/L 07.04.19*

2.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: *M103987*

*P/L 07.04.19*

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 5 D2235-1 From D3166-1

2- Cut Ribs as per Dwg D2252

3-Drill hole in D2252-1as per Dwg D2252

4-Deburr & Remove all Markings from Material

*P/L 07.04.19*

4.0 D22531 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 2 D2253 Gusset *B21553*

*P/L 07.04.19*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 3/26/2007 3:02:19 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE - UNDER REVIEW

Job Number: 31454A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing 328597

*Cpl 07-04-19*

6.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Channel 330552

*Cpl 07-04-19*

7.0

D2254

Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug 323421

*Cpl 07-04-19*

8.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 HINGE 329132

*Cpl 07-04-19*

9.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description Batch

32 sf M304EX0.75-16F Expanded Metal M163949

*Cpl 07-04-19*

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig Debur as required

A/R SS ROD Batch: M101972

*Cpl 07-04-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Q Date: 07/04/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:02:19 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE - UNDER REVIEW

Job Number: 31454A

Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/19

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/19

13.0

POWDER COATING

POWDER COATING



M 103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

HL

07-04-19

①

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/04/20

x1

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/04/20

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/20

Job Completion

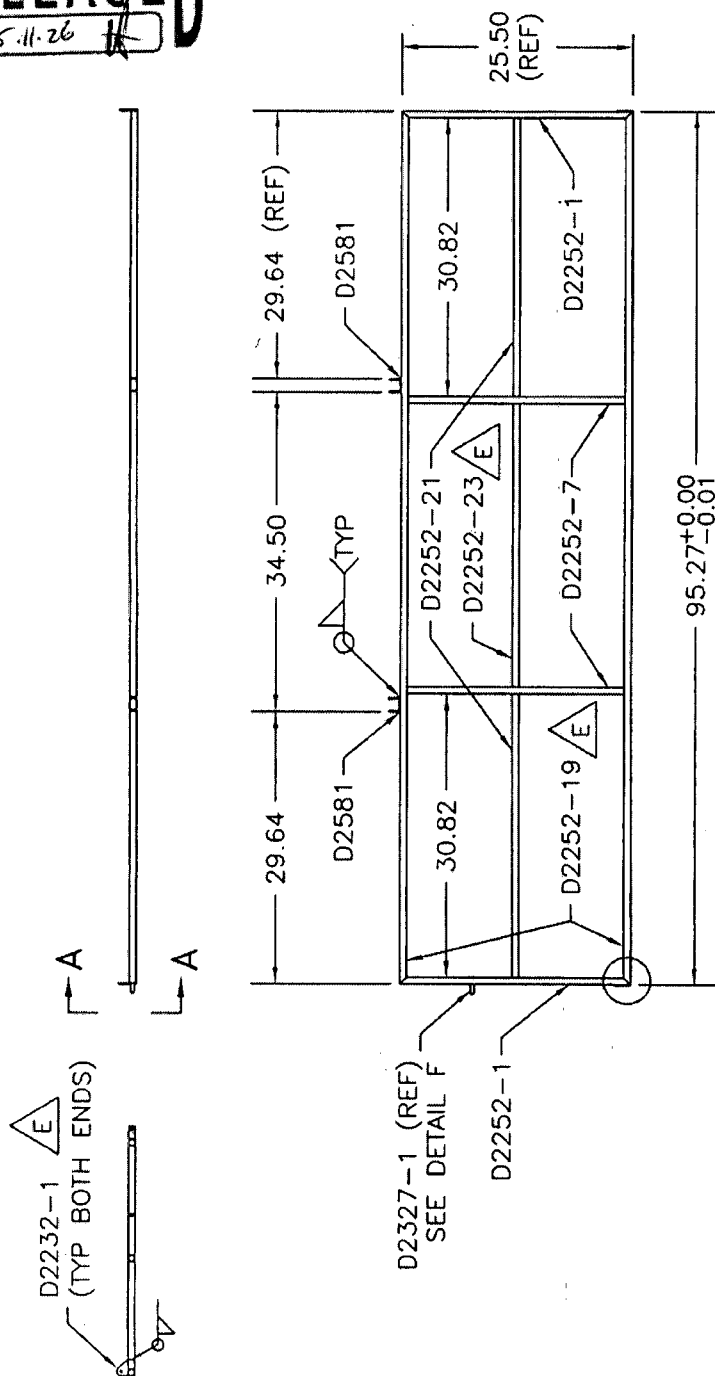


4 07/04/20



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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)		SCALE NTS

RELEASED  
05.11.26



D2252-043 LID FRAME



WELD ALL JOINTS  
AS SHOWN

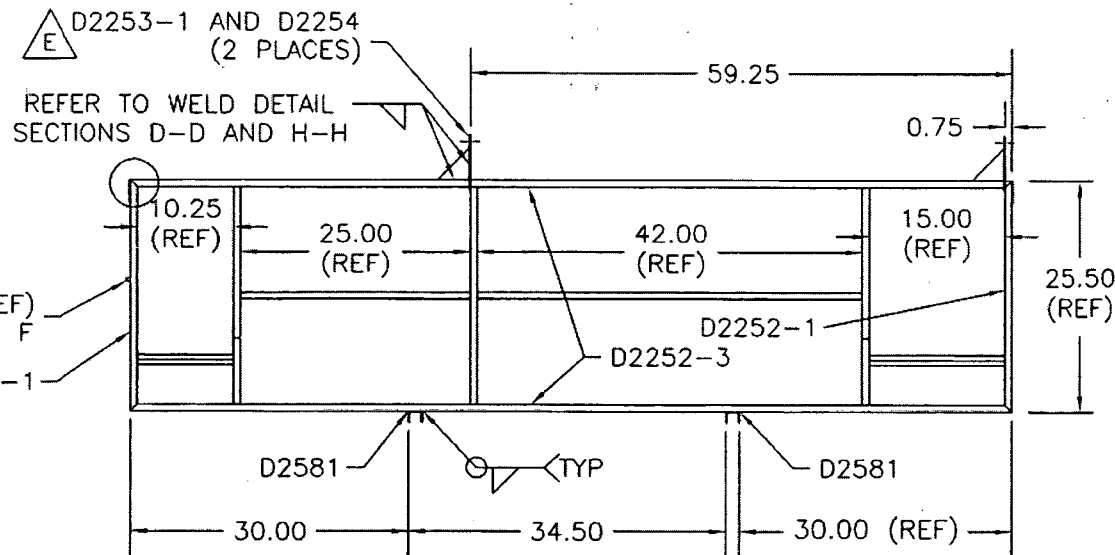
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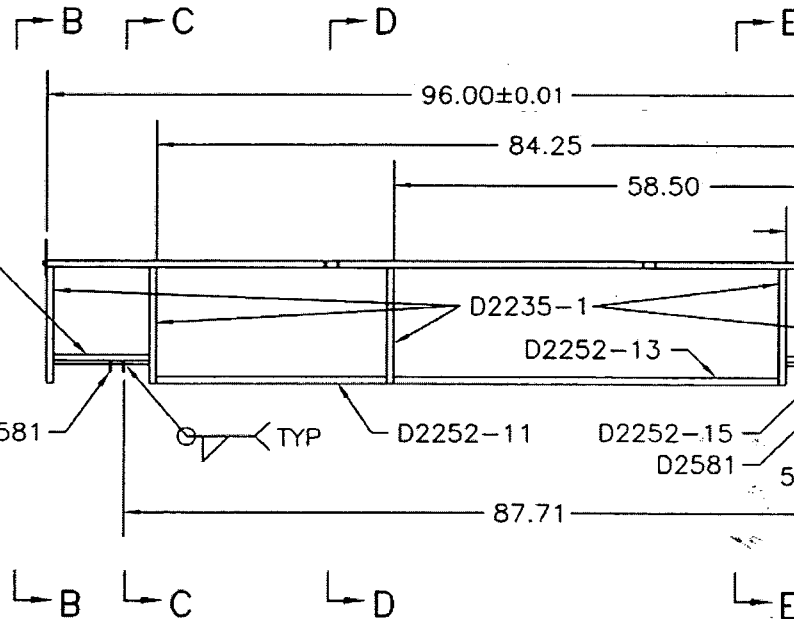
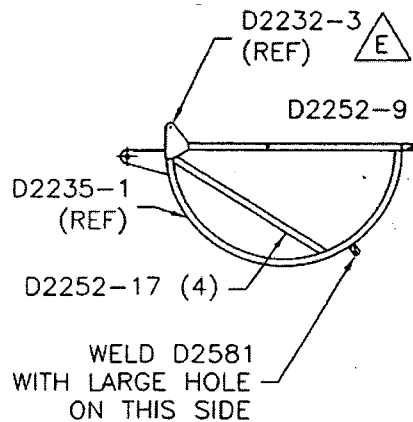
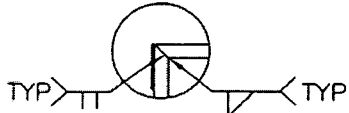
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DATE	05.11.10	TITLE	BASKET ASSEMBLY (206L)	REV. E SHEET 3 OF 5
		SCALE	NTS	



WELD ALL JOINTS  
AS SHOWN



D2252-041 BASKET FRAME

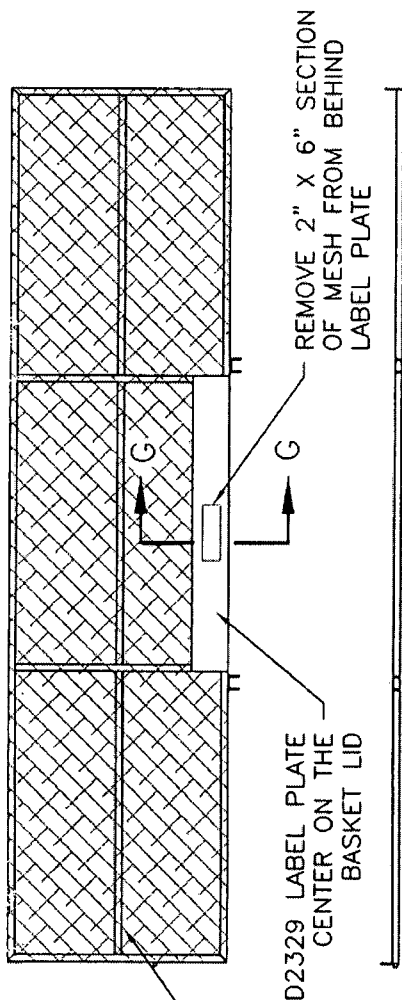
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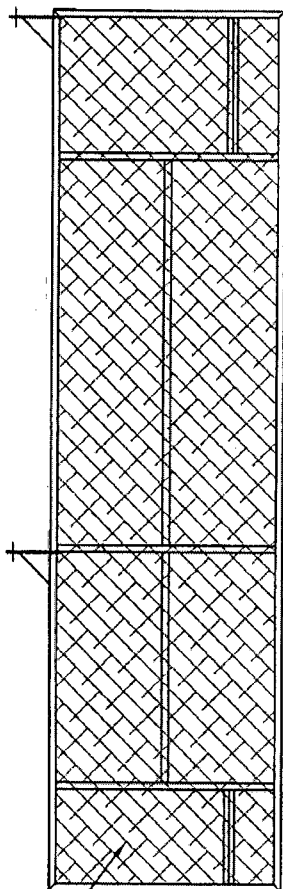
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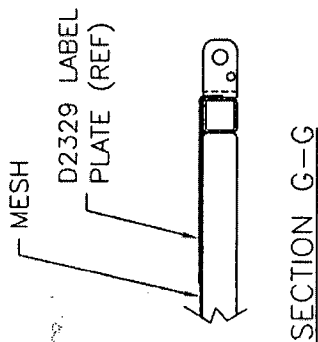


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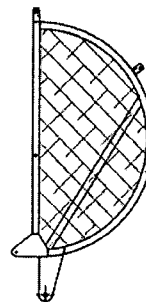


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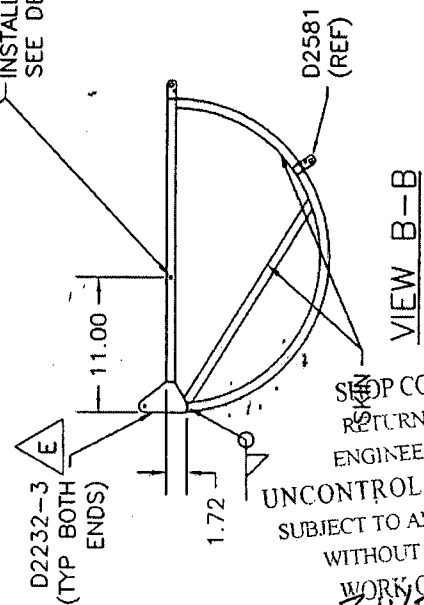
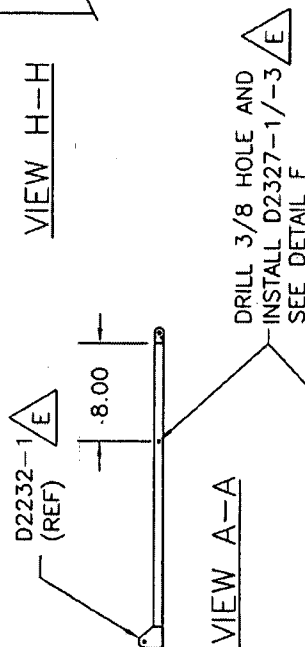
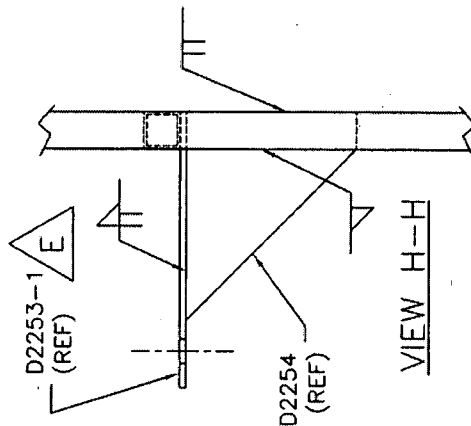
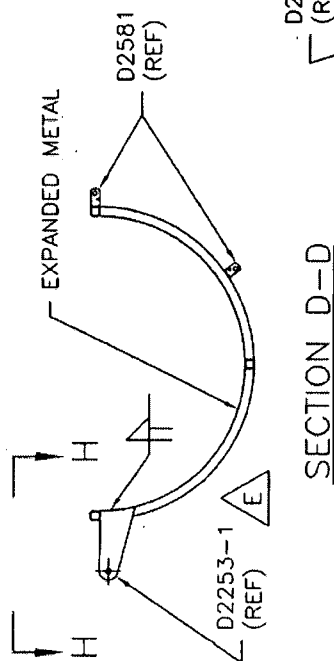
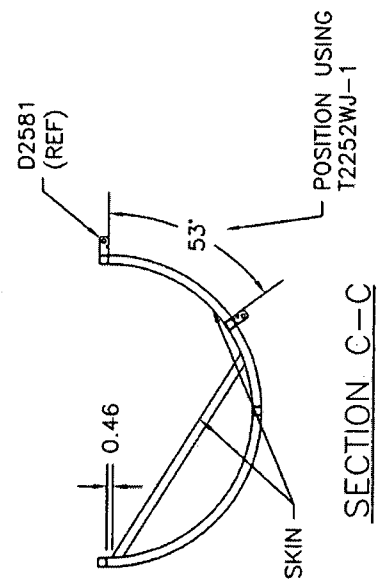
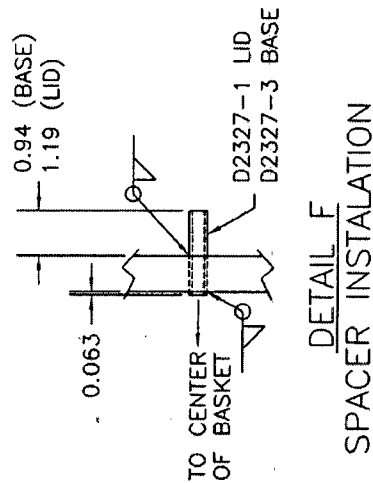
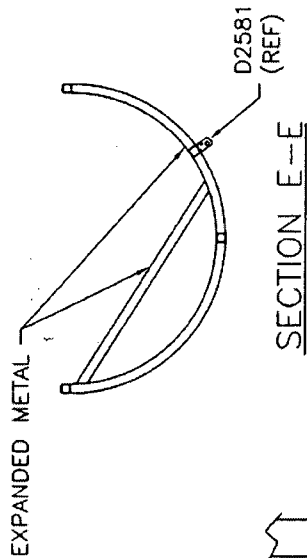
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